



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D2010-101
Job Sheet 200103



Part No: D2010-101

Job Qty: 8 pcs

Part Name: Mirror Bracket 369/500



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP: E 02.06.25 Added Rev. C1 KJ /RF IPP Rev:F 07-08-015 Now on WaterJet Verified By:EC
IPP Rev:G 08-05-27 as per ECN1195P DD verified by:EC IPP Rev:H 08-06-20 rev.D as per dwg DD verified
by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		10/4/19	0.17	0.50	Waterjet - Flow		JRB 11/11/19
110	QC 2	8 pcs		10/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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CANADA
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Container No: S230518

Part: D2010-101

Job No: 200103

Serial No/Batch: S230518

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/11/19

PRIORITY

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9/6/2019

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120 QC 8	8 pcs	10/4/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 11/11/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	DAS NOV 11 2019 68
				QC 8 - 67	9-89
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	8 pcs	10/4/19	0.25 0.88	Small Fab - Brake - 1 - B4B	DAS NOV 11 2019 30
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
145 Handfinish - 1-1 Chemical-B4B	8 pcs	10/4/19	0.00 0.21	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 11 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
147 QC 7	8	10/4/19	0.00 0.00	QC 7 - 10	

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	pcs				QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
150 Small Fab - 2 - B4B	8 pcs	10/4/19	0.00 0.36		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
160 QC 5	8 pcs	10/4/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Powdercoat - 4 Black Sand - B4B	8 pcs	10/4/19	0.00 0.14		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	

NOV 12 2019

DAS NOV 12 2019

DAS NOV 12 2019 68 9-89

M156440

START 8:30 CUT: 3:30 FINISH 9:00

BL 19-11-13

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9/6/2019

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			Powdercoat - 4 - B4B		
180 QC 3	8 pcs	10/4/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	NOV 13 2019
				QC 3 - 19	DAS 40 9-89
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
190 Packaging 3-1 - Stock - B4B	8 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 74 NOV 13 2019
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
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200 QC 21 - SA		8	10/4/19	0.00 0.00	Packaging 3 - 36 - B4B	DAS
		pcs			QC 21 - SA - 21	21
					QC 21 - SA - 70	9-50
					QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D2010-101

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - Form as per Dwg D2010

145 - (Chemical Conversion Coat per QSI005 4.1)

147 - (QC7-Inspect Chemical Conversion Coat)

150 - Install fasteners per Dwg D2010

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3), ***INSTALL BOLT IN INSERT PRIOR TO POWDER COAT*** START TIME _____ OVENTEMPERATURE: _____ FINISH TIME _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

NOV 13 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
FE-032-EF	Inserts Alt: FE-032-MD	32 Ea (4 ea)	100-Waterjet - Flow - 1	5180490
M2024T3S.063	2024-T3 .063 Sheet	2.7776 sf (.3472 ea)	150-Small Fab - 2 - B4B	

CA005 CA078

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	FE-032-EF	32	14	0
150-Small Fab - 2 - B4B	M2024T3S.063	3	87	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD		Work Order:	200103
Description: Bracket		Part Number:	D2010-101
Inspection Dwg: D2010	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.56	+/-0.030	6.56	✓		JRB-02V	
5.81	+/-0.030	5.83				
0.38	+/-0.030	0.377				
0.75	+/-0.030	0.752				
0.38	+/-0.030	0.377				
1.375	+/-0.010	1.372				
Ø0.290	+0.005 -0.000	0.292				
7.05	+/-0.030	7.06				
Ø0.201	+0.005 -0.000	0.202				
6.30	+/-0.030	6.302				

Measured by: JRB	Audited by:	Preliminary Approval:
Date: 11/11/19	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	03.10.06	New Issue	KJ/RF	
B	06.03.08	Dwg rev. changed	KJ/JLM	
C	08.07.22	Dimension 5.06 removed	KJ/DD	
D	11.03.17	Dimension 7.05 revised	KJ	



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____